



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4634-045
Job Sheet 185042



006748

Part No: D4634-045

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D4634 REV.G IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED
BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg
update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/18	0.00	0.00	Start Up Small Fab		Smb
100	Small Fab	1 pcs		11/23/18	0.00	0.50	Small Fab		Smb
110	Small Fab	1 pcs		11/23/18	0.00	0.50	Small Fab		Smb
120	QC	1 pcs		11/23/18	0.00	0.00	QC5		3845
130	Packaging	1 pcs		11/23/18	0.00	0.00	Packaging3		9-89
140	QC21-SA	1 Ea		11/23/18	0.00	0.00	QC21		9-89

Part Op 110 - ***BEFORE INTALLING D4728-055, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART
Descriptions: ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : 138996 1-
Assemble as per Dwg D4634-045 2- install No Smoking & seat belt symbols 3- Install led lights 4- Install Air valves
5-Install Wiring Harness

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud S+578	1 Ea (1 ea)	90-Start up Operation	5007846
50-009-2	Grommet STS83	1 Ea (1 ea)	90-Start up Operation	5004860
D4634-145	Aft, Center Ceiling Replacement Panel Assembly	1 Ea (1 ea)	90-Start up Operation	5133429
D4646-1	Plenum Cap Assembly mfo09	2 Ea (2 ea)	90-Start up Operation	5137524
D4652-3	Mounting Nut mfo09	2 Ea (2 ea)	90-Start up Operation	5011749
D4652-5	Air Valve, 1.25 Id Disk Type mfo03	2 Ea (2 ea)	90-Start up Operation	5083070
D4728-049	Advisory Light, Aft mfo09	1 Ea (1 ea)	90-Start up Operation	5084071
D4728-055	Cabin Lights #3 mfo02	1 Ea (1 ea)	90-Start up Operation	5084991
PLT1.5M-M	Tie Wrap STS70	10 Ea (10 ea)	90-Start up Operation	5025404

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-27-C3C	1	37	0
	50-009-2	1	185	0
	D4634-145	1	0	0
	D4646-1	2	16	0
	D4652-3	2	207	0
	D4652-5	2	11	0
	D4728-049	1	11	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4728-055
PLT1.5M-M

1
10

1
2,169

0
0

Part Specifications

Specifications could not be found.

Plex 10/22/18 11:04 AM Dart.lajeunesse.marie

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134245



Part: D4634-045

Job No: 185042

Serial No/Batch: S134245

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								